

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028383**Date Inspected:** 10-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower / OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing of ESW**ESW R Face B:**

This QA performed Ultrasonic Testing (UT) on approximately 1850mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW R" face B. Location (Y=5150~7000) of this weld was inspected using this testing method.

This weld was previously accepted by QC Ultrasonic technicians in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

This testing is in progress. No indications have been jointly confirmed at this time. Tracking will be completed once testing has been resumed.

*Note: Due to stiffener plates (2 x's 45mm) and the 9m diaphragm plate (1 x's 50mm) approximately 140mm of this weld could not be full volumetrically scanned from this face.

This QA has not generated a TL-6027 UT report on this date.

ESW S Face B:

This QA performed Ultrasonic Testing (UT) on approximately 1850mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW S" face B. Location (Y=5150~7000) of this weld was

WELDING INSPECTION REPORT

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inspected using this testing method.

This weld was previously accepted by QC Ultrasonic technicians in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

This testing is in progress. No indications have been jointly confirmed at this time. Tracking will be completed once testing has been resumed.

*Note: Due to stiffener plates (2 x's 45mm) and the 9m diaphragm plate (1 x's 50mm) approximately 140mm of this weld could not be full volumetrically scanned from this face.

This QA has not generated a TL-6027 UT report on this date.

This QA performed UT of weld designated as ESW W in accordance with the approved supplemental procedure. This testing was performed in tandem with QC technician Andrew Keech. Tandem report for work performed on this date will be completed by QC technician and signed by both QA/QC parties. Items listed on tandem report reflect indications agreed upon by QA/QC. Due to QA/QC disagreement on indication interpretation, tandem report may not reflect all indications discovered by QA at time of testing.

Note: Approximately 3:30pm QC Andrew Keech was called by telephone by his immediate supervisor and told to halt ESW joint testing at this time. Mr. Keech and this QA had not completed joint verification of indications at that time. This QA was told to also halt testing and report to the Orthotropic Box Girder portion of the project for reassignment. At this time this QA has not submitted a TL-6027 or a joint Ultrasonic Testing (UT) report form. Once testing has recommenced this QA and a joint QC will verify initial findings as per testing agreement.

ESW RWR Tracking

This QA was instructed by Task Leader Bill Levell to generate a spread sheet for the tracking of Request for Weld Repair (RWR) forms submitted by ABF for the repair of Electroslag Welds located at the base of the Tower. This assigned task requires review of all submitted RWR's as well as review of approved QA TL-6031 report forms applicable to this welding, testing, and repair. This QA used the balance of time not allocated for in-process inspection and testing to work on this task.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations were relevant to work performed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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| Inspected By: | Clifford, William | Quality Assurance Inspector |
| Reviewed By: | Levell, Bill | QA Reviewer |
